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मानक

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IS 12325 (1988): Circular Screwing Dies for ISO Metric
Conduit Pipe Threads [PGD 32: Cutting tools]



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“Knowledge is such a treasure which cannot be stolen”

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AMENDMENT NO. 1 APRIL 1990
TO
IS 12325 : 1988 SPECIFICATION FOR CIRCULAR
SCREWING DIES FOR ISO METRIC CONDUIT PIPE
THREADS

(Page 1, clause 3, table, sixth column) — Substitute ' h ' for ' l ₁ '.

(PE 13)

Reprography Unit, BIS, New Delhi

Indian Standard

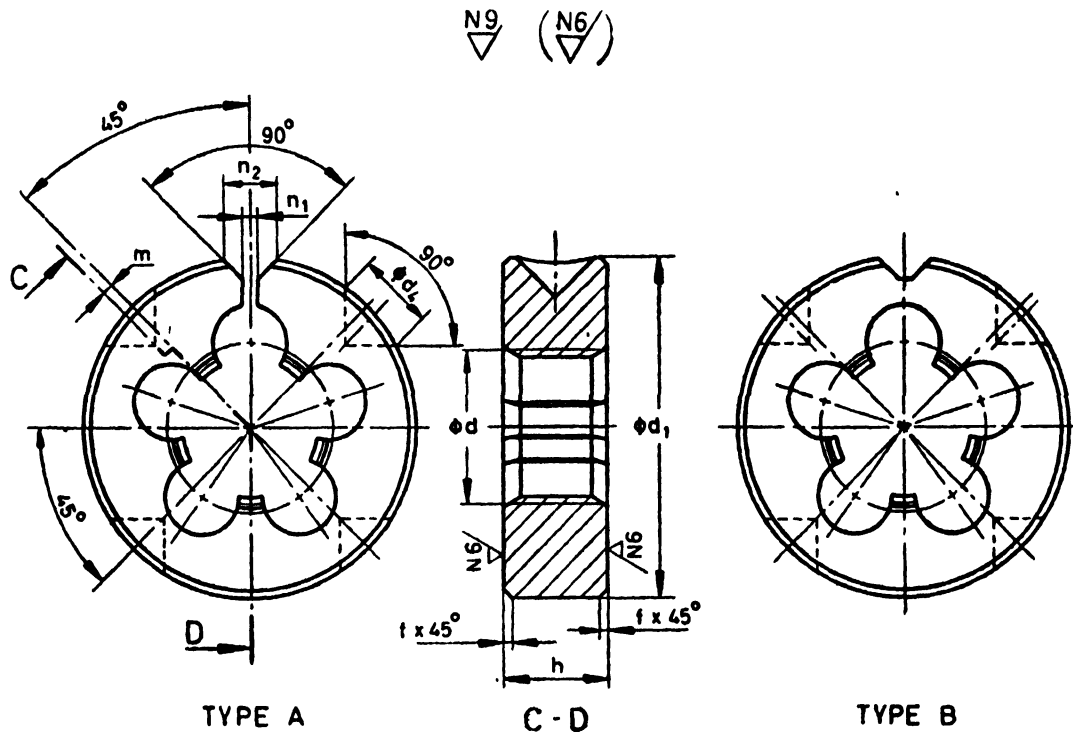
SPECIFICATION FOR CIRCULAR SCREWING DIES
FOR ISO METRIC CONDUIT PIPE THREADS

1. Scope — Covers the dimensions and other requirements for circular screwing dies intended for producing ISO metric conduit pipe threads conforming to IS : 9537 (Part 2)-1981 'Specification for conduits for electrical installations: Part 2 Rigid steel conduits'.

2. Types — These shall be of two types.

- a) *Type A* — Adjustable circular screwing dies, and
- b) *Type B* — Solid circular screwing dies.

3. Dimensions



Adopted 23 September 1988

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

4. Material and Hardness — Shall be as given in IS : 12320-1988 'Technical supply conditions for circular screwing dies'.

5. General Requirements

5.1 All dies shall be provided with chamfer on both sides. The maximum chamfer diameter shall not exceed ' d_5 ' (see IS : 12320-1988). The values of d_5 are applicable for cutting steels having tensile strength not exceeding 500 MPa. When the dies are required for cutting materials having tensile strength greater than 500 MPa, the same shall be mentioned with the order, so that the chamfer length could be increased by reducing the chamfer angle.

5.2 All circular dies shall be provided with conical holes or alternatively, V-grooves perpendicular to the axis of the die for the purposes of holding and adjusting. The arrangement of these conical holes shall be as shown in relevant dimensional table (see 3).

5.3 The number of cutting edges and the provision or omission of recess (d_3) shall be at the discretion of the manufacturer, unless otherwise agreed upon between the purchaser and the manufacturer.

5.4 Right hand cutting dies shall be supplied, unless otherwise specified. Dies for left-hand cutting with left-hand cutting threads shall be marked with the letter 'LH' appropriately.

5.5 Unless otherwise specified, the dimensions of the threads for dies shall be such as to produce bolt threads within the tolerance class '6g' as specified in IS : 4218 (Part 4)-1976 'ISO metric screw threads: Part 4 Tolerancing system'.

5.6 Die holder shall be according to IS : 3239-1983 'Specification for die holder for circular thread cutting dies'.

5.7 For requirements not covered in this standard, it shall conform to IS : 12320-1988.

6. Workmanship and Finish — The die shall be finished, smooth and ground all over. They shall be free from burrs, cracks, seams or other manufacturing defects.

7. Sampling — The sampling and the criteria of acceptance shall be according to IS : 7778-1975 'Method for sampling small tools'.

8. Designation — A circular screwing die of Type A for producing conduit thread of nominal size 40 mm and made from high speed steel shall be designated as:

Circular Screwing Die A 40 IS : 12325

8.1 When the die is required with left hand cutting, the letter 'LH' shall be added before the nominal size in the designation.

9. Marking — The dies shall be marked with nominal size, material and manufacturer's name or trade-mark.

9.1 Standard Marking — Details available with the Bureau of Indian Standards.

10. Preservative Coating and Packing — Shall be as given in IS : 12320-1988.

EXPLANATORY NOTE

The basis of formulation of this standard is the adoption of ISO metric screw thread for conduit pipes in accordance with IS : 9537 (Part 2)-1981 'Specification for conduits for electrical installations: Part 2 Rigid steel conduits' and the prevalent practices in the Indian industry.

This standard is one of the standards on circular screwing dies. Other standards are:

- IS : 12319-1988 Circular screwing dies — General table of dimensions
- IS : 12320-1988 Technical supply conditions for circular screwing dies
- IS : 12321-1988 Circular screwing dies for ISO metric threads
- IS : 12322-1988 Circular screwing dies for taper pipe threads, R-series
- IS : 12323-1988 Circular screwing dies for parallel pipe threads, G-series
- IS : 12324-1988 Hexagonal die nuts